

Page 1

Wednesday, Jul	ly 13, 2011 10	0:21:03 AM				*			
Item ID:	D3503-1			Accept				Setup Start	
Revision ID:								Ston	1 10011101 01010 101 1101 1001
Item Name:	Cup						•	Stop	
Start Date:	7/14/2011	Start Qty: 60.00			Cust Item ID):	,		
Required Date	: 7/28/2011	Req'd Qty: 60.00			Customer:				
Reference:									
Approvals:	Process Pla	an: MF	Date:[]-07-13	Tooling:	Dat	te:		Run Start	
	QC:		Date:	SPC (Y/N):	Dat	te:		Stop	
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty		Reject Insp. Number Stamp
Draw Nbr	Rev	vision Nbr						,	
D3503	Rev						/4	. ,	
100		Hardinge CNC LATHE	SMALL	0.00			(Z	b	-
Hardinge		Memo	· · · · · · · · · · · · · · · · · · ·	0.00		1			
Hardinge CNC Lat	the Small	FOLIO REV DWG REV:	S PERFOLIO FA635 & D	108	12	j			;
110		QC2- Inspect parts off m	nachine FAI/FAIB	0.00	- المستوان و		65	· /	
		çoz maştat parta on ti			•		63	5 \$	
QC		Memo		0.00			. —	•	
Quality Control	e e e e e e e e e e e e e e e e e e e			D W	812				
120 		QC8- Inspect parts - second	ond check	0.00			··· • .	<u> </u>	
QC Quality Control		Мето		ه. کل ۵۵.۵	11/08/02		64	φ	
Quanty Control	٠.	* * * * * * * * * * * * * * * * * * *							

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W/O:		·	WORK ORDER CHANGES									
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector			
							-	Prod Mgr	•			
				,								
Part No	•	PAR #:	Fault Cat	legory:	_ NCR: Yes	No DQ	A:	Date: _	<u></u>			
		esolution:										
NCR:	pies.		WORK ORI	DER NON-CONFORMA	ANCE (NCI	R)						
DATE	STEP	Description of NC	Corrective Action		ion B	Verific	cation	Approval	Approval			
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date	& Secti	ion C	Chief Eng	QC Inspector			
				•					,			
	<u> </u>											

NOTE: Date & initial all entries

Work Order ID 71843

Wednesday, July 13, 2011 10:21:03 AM



Page 2

Item ID:

Revision ID:

D3503-1

Item Name: Cup

OC:

7/14/2011

Req'd Oty: 60.00



Accept

Setup Start

Stop



Start Date: **Start Otv:** 60.00 **Cust Item ID:** Required Date: 7/28/2011 **Customer:**

Reference:

Approvals:

Process Plan:

Date:

Date: _____ Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date: Date: Run Start

Stop

Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

0.00

0.00

Tool ID

Tool # Plan

Accept Otv Code

Reject Otv

Reject Number

Insp. Stamp

140

OC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

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WORK ORDER CHANGE DATE STEP PROCEDURE CHANGE By Date Oty Chief Eng. Proof Mgr Part No: PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: NCR: WORK ORDER NON-CONFORMANCE (NCR) DATE STEP Description of NC Section A Chief Eng Chie			
Part No:PAR #: Fault Category: NCR: Yes No DQA: Date:	W/O:		
Resolution:	DATE STEP P		
Resolution:			
Resolution:			
NCR: WORK ORDER NON-CONFORMANCE (NCR) DATE STEP Description of NC Section A Popolar Initial Action Description Sign & Section C Chief English	Part No:		
DATE STEP Description of NC Section A Section B Section B Verification Approval Chief English Content of No. Section A Section C Section C Chief English Content of No. Section B No. Sec			
DATE STEP Description of NC Section A Initial Action Description Sign & Verification Approval	NCR:		
Section A Initial Action Description Sign & Section C Chief Eng	DATE	Approval	
	DAIL	QC Inspector	

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 13, 2011 10:21:00 AM

Work Order ID: 71843

Parent Item: D3503-1

Parent Item Name: Cup



Start Date: 7/14/2011

Required Date: 7/28/2011

Page 1

Start Qty: 60.00

Required Qty: 60.00

Comments:

IPP Rev:A New Issue 06-05-04 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.000		Purchased	No			100	f	62.8500	0.065	4.105263	1.	W/	7

304 round bar 1.00

Location	Loc Qty	Loc Code
MAT029	62.85	
109508	12.5	
109541	2.18	
113457	48.17	



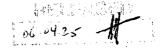
Dart Aerospace Ltd

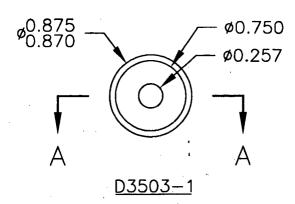
- 4117101										
W/O:		(A-4/W)	W	ORK ORDER CHANGES	3					
DATE	STEP	PRO	CEDURE CHA	DURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		·								
Part No	.	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:		
					QA: N/C Closed: Date:					
NCR:		V	VORK ORD	ER NON-CONFORMAN	ICE (NCR)				
DATE	STEP	Description of NC			V6			Approval	Approval	
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector	
	!									
							-			

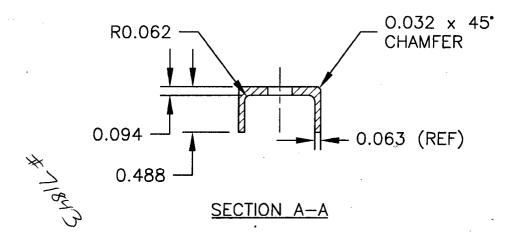
NOTE: Date & initial all entries



DESIG	PH	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECK	(中)	APPROVED A	DRAWING NO.	REV. A
.	Mek	4	D3503 SHEET 1	OF 1
DATE		* ****	TITLE	SCALE
06.0)4.19		CUP	1:1
Α		06.04.19	NEW ISSUE	







D3503-1 CUP

- AISI 304/316 STAINLESS STEEL ROUND BAR MATERIAL: (REF DART MATERIAL SPEC M304RX.XXX)
- ALL DIMENSIONS ARE IN INCHES 2)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD	Work Order:	71843	
Description: Cup	Part Number:	D3503-1	
Inspection Dwg: D3503 Rev: A		Page 1 of 1	

		RTICLE INSP	ECTION	CHEC	יאו ופ	e T	
	F	First Article		Protof		, ,	
Drawing	Tolerance	Actual	Accept	Reje		Method of	Comments
Dimension		Dimension				nspection	
Ø0.875	+0.000/-0.005	0.873				NX	
Ø0.750	+/-0.010	0.752	//				
Ø0.257	+0.006/-0.001	0.258					
0.488	+/-0.010	.488					
0.094	+/-0.010	.0925	_/				
0.063 Ref	Min 0.055 Max 0.0675	,019					
R0.062	+/-0.010	R.060					
0.032 x 45°	+/-0.010 x +/-0.5°	032175					
	-	·					
							
							<u></u> :
Measured by:	AL	udited by:	LA		Protot	ype Approval	: N/A
Date:	11)8/2		108/02			Date	: N/A
Rev Date A 07.10.2	Change 4 New Issue					Revised by KJ/EC/DD	Approved

H:\FORMS\Quality Assurance\approved QA	\FAI revD